



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3812
Job Sheet 185767



Part No: 646.3812

Job Qty: 20 ea

Part Name: Gusset Bracket



Dec-6

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/1/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 646.3800 REV.A IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD IPP REV:B 18.07.03 AS PER DWG REV.A DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		11/23/18	0.00	0.00	Start Up Machining-1		
100	Bandsaw	20 pcs		11/23/18	0.00	4.64	Bandsaw1		
110	Mill Conv	20 pcs		11/23/18	0.00	9.39	Mill Conv 1		
120	QC	20 pcs		11/23/18	0.00	0.00	QC2 Machining-1		
130	QC	20 pcs		11/23/18	0.00	0.00	QC8 Machining-1		
140	Outsource	20 pcs		11/23/18			ATG001-VC	8	
150	Packaging	20 pcs		11/23/18	0.00	0.00	Packaging2		
155	QC	20 pcs		11/23/18	0.00	0.00	QC5		
180	Packaging	20 pcs		11/23/18	0.00	0.00	Packaging3-1		
190	QC21-SA	20 Ea		11/23/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine per DWG

Descriptions: 140 - Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required
180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6A0.75X0.75X0.060X0.062	7075T6 Angle .75" X .75" X .060" X .062"W	2 ft (.1 ea)	90-Start up Operation	M136405

each Part = 2"lg

DAS 10 3.5 ft is Req.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6A0.75X0.75X0.060X0.062	2	28	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Gusset Bracket	2.000Inches ± 0.010	2.010 1.990		
2	Gusset Bracket	0.060Inches ± 0.010	0.070 0.050		
3	Gusset Bracket	0.750Inches ± 0.010	0.760		

37"1e4

Work Order update only

Work Order: _____		DISPOSITION Rework ☐ ☐ Scrap ☐ ☐ Use-as-is ☐ ☐ Suspected Unapproved ☐ ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ ☐ Machining ☐ ☐ Thermoforming ☐ ☐ Large Fab ☐ ☐ Cross tube ☐ ☐ Small Fab ☐ ☐ Finishing ☐ ☐ Composite ☐ ☐ Water Jet ☐ ☐ Prod. Eng. Coord. ☐ ☐ Rec/Store/Packaging ☐ ☐ Supplier ☐ ☐ Engineering ☐ ☐ Quality ☐ ☐ Other ☐ ☐																			
Part No. _____																							
NCR No. _____																							
Date : _____		Step #:		QTY Effective :																			
Description Work Order Deviation				Disposition																			
												Completed By											
												Lead hand / Supervisor Approval Verification											
												QC / QA Coordinator Approval											
Root Cause				FAULT CATEGORY																			
Environment: ☐				No Re-verification ☐				Pressure/Forced ☐				Temperature/Cure ☐				Power Loss/Surge ☐				Positioned Wrong ☐			
Design ☐				Operator ☐				Bending ☐				Set-up ☐				Folio/Program ☐				Outside Dimensions ☐			
Doc/Data ☐				Offset/Setup ☐				Centre Not Concentric ☐				BOM/Route ☐				Grain ☐				Over/Under tolerance ☐			
Equip/Tooling ☐				Supplier ☐				Cracks ☐				Broken/Damage/Defect ☐				Weld ☐				Part Incorrect ☐			
Handling/Pre ☐				Training ☐				Crimp/Kink/Ripple/Wave ☐				Inspection Incomplete/Unqualified ☐				Wrong Stock Pulled ☐				Part Lost/Missing ☐			
Material ☐				Use for Testing ☐				Cuffs ☐				Contamination ☐				Out of Sequence ☐				Part Moved ☐			
Internal Transport ☐				Poor Information ☐				Crushing ☐				Countersink ☐				Off-set ☐				Drawing ☐			
Tribal Knowledge ☐				Rushing ☐				Heat Treat ☐				Cut Too Short ☐				Mislabeled ☐				Finish ☐			
LOA ☐				Product Improvement ☐				Wave/Twist in Tube ☐				Instructions Incomplete/Unclear ☐				Fit/Function ☐				Misread ☐			
Substation ☐				Process Improvement ☐				Marks/Chatter ☐				Drill Holes ☐				Misaligned/off center ☐				Turning Sequence ☐			
Past Expiry Date ☐				Manufacturing Process ☐				OTHER :															
Misidentified ☐				Past Due ☐																			

			0.740
4	Gusset Bracket	0.060Inches $\pm$ 0.010	0.070 0.050
5	Gusset Bracket	0.310Inches $\pm$ 0.010	0.320 0.300
6	Gusset Bracket	0.060Inches $\pm$ 0.010	0.070 0.050
7	Gusset Bracket	0.380Inches $\pm$ 0.010	0.390 0.370
8	Gusset Bracket	1.250Inches $\pm$ 0.010	1.260 1.240
9	Gusset Bracket	0.090Inches $\pm$ 0.010	0.100 0.080

Plex 11/1/18 2:33 PM Dart.lajeunesse.marie



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S131076



Part: 646.3812

Job No: 185767

Serial No/Batch: S131076

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 11/23/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date: _____		Step #: _____		QTY Effective: _____			
Description Work Order Deviation		Disposition					
Root Cause		FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : _____							

Completed By _____
 Lead hand / Supervisor
 Approval Verification
 QC / QA Coordinator
 Approval



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

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PURCHASE ORDER **PO041883**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

PO No: PO041883
PO Date: 11/28/18
Due Date: 12/11/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Attention: Lalande, Marc-Andre

Via: Ground
Pymt Terms: Net 30

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Freight Terms:
Special Comments:

*reused PO

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	178970	RBE703A94-1130-01-27	Tab Adjuster Body -Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 Water seal -Certificate of Conformity is required	Firmed	-	11/30/18	5 pcs	0 pcs	5 pcs	\$5.80/pcs	\$29.00
5 X NOV 30 2018											
Line Item Note ** ASAP by Friday morning **											
2	184442	RBT18601	Main Rotor Swashplate ReGreasing Tool -Issue P/O to ATG; PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; -Certificate of Conformity is required	Firmed	-	11/30/18	8 pcs	0 pcs	8 pcs	\$5.80/pcs	\$46.40
8 X NOV 30 2018											
Line Item Note ** ASAP by Friday morning **											



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PURCHASE ORDER **PO041883**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	185913	C45-1-1	Manual Knob Release -Issue P/O to ATG; PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061 -Certificate of Conformity is required As Per DWG C45-1-1	Firmed	-	11/30/18	10 pcs	0 pcs	10 pcs	\$5.80/pcs	\$58.00
Line Item Note ** ASAP by Friday morning **											
4	185767	646.3812	Gusset Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	12/5/18	20 pcs	0 pcs	20 pcs	\$7.20/pcs	\$144.00



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PURCHASE ORDER **PO041883**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	185768	646.3813	AS350 Strut Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	12/5/18	20 pcs	0 pcs	20 pcs	\$7.20/pcs	\$144.00
6	186252	650.9201	Eyelet Bracket Assembly Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 650.9200	Firmed	-	12/6/18	20 pcs	0 pcs	20 pcs	\$7.70/pcs	\$154.00
7	186245	646.3610	Filler Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3600	Firmed	-	12/11/18	16 pcs	0 pcs	16 pcs	\$7.70/pcs	\$123.20



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PURCHASE ORDER **PO041883**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	185766	646.3810	Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	12/5/18	20 pcs 21	0 pcs	20 pcs	\$7.65/pcs	\$153.00
9	185799	646.9710	Body Issue P/O to ATG : Hard Black Anodize Color Black and Prime as per Dwg 646.9700	Firmed	-	12/6/18	10 pcs 10 X	0 pcs	10 pcs	\$15.60/pcs	\$156.00
10	186661	RBT112800-1	Base -Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL As per Dwg RBT112800 Rev. 3A -Certificate of Conformity is required	Firmed	-	12/6/18	13 pcs 13 X	0 pcs	13 pcs	\$5.80/pcs	\$75.40
Grand Total: \$1,083.00											



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PURCHASE ORDER PO041883

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/30/18 10:12 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916826

Date: 17-Dec-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 20 ea	Part: 646.3812 ✓ Gusset Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24227		Rev: N/C PO: PO041883 ✓ Line: 4
✓ 20 ea	Part: 646.3813 ✓ AS350 Strut Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24228		Rev: NC PO: PO041883 ✓ Line: 5
✓ 20 ea	Part: 650.9201 ✓ Eyelet Bracket Assembly Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24229		Rev: A PO: PO041883 ✓ Line: 6
✓ 16 ea	Part: 646.3610 ✓ Filler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24230		Rev: N/C PO: PO041883 ✓ Line: 7
✓ 21 ea	Part: 646.3810 ✓ Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6		Rev: NC Made in Canada. ^

Made in Canada. ^



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916826

Date: 17-Dec-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	- .9 mils) per drawing. Job: 24231	PO: PO041883	Line: 8
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>17/12/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

